

SAP 28/04

Date: Tuesday, 08/04/2008 4:54:53 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: R/H STEP ASSY		
Job Number	: 38462						
Estimate Number	: 13170						
P.O. Number	:				Part Number	: D3724042	
This Issue	: 08/04/2008		S.O. No.	: :	Drawing Number	: D3724 REV B	
Prsh Rev.	: NC				Project Number	: N/A	
First Issue	: / /		Type	: LARGE FAB ASSY	Drawing Revision	: B	
Previous Run	: 38219				Material	:	
Written By	:				Due Date	: 25/04/2008	
Checked & Approved By	: JD 08-4-09				Qty:	1 Um: Each	
Comment	: Est Rev:A new issue 08-02-07 DD verified by: Est Rev:B ecn 1154p 08-03-13 DD verified by: Est Rev:C ecn 1158 08-03-19 DD verified by:						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Qty Part # Description Batch: 1.25 D2622-120C Extrusion 36923	
		Check Material for any Dents or Defects	SAP 08/04/10 ①
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		1-Cut D3737-2 as per dwg D3737	
		2-Cut D3738-2 as per dwg D3738	
		3-Deburr and bevel ends for welding	SAP 08/04/10 ②
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	08-04-13
4.0	D37331	GUSSET	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) GUSSET batch 338468	
			08-04-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3738-1, D3737-1 and D3733-1 as per dwg D3724

1208-04-15
1208-04-15

2-Grind flush

6.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

1208-04-16

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

1208-04-16

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

206 Step Endplate

batch B36520

1208-04-16

11.0 D37281

STEP BRACKET



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

PLATE

batch B38223

x3 ✓

ml

12.0 D37291

STEP BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PLATE

batch B38468

x1

ml

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Job Number: 38462

Part Number: D3724042

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 D37301 ANGLE



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

ANGLE
batch

B37843 x2 ✓ B38600 x6

ml

14.0 D37411 ANGLE



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

ANGLE
batch

B38224 x4 ✓ B38470 x4

ml

15.0 MS20470AD511 Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet
batch

M107100

✓

ml

16.0 MS20470AD516 Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet
batch

M107100

✓

ml

17.0 CR321354 Cherry Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Cherry Rivet
batch

M107100

✓ 08-04-22

18.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

GA
1-Apply Magnobond before installing rivets
A/R Magnobond 6398 Batch: M1C4723

2-Rivet D3741-1 and D3730-1 to brackets before installing on step as per dwg D3724

3-Transfer holes from D3730-1 and D3741-1 into step as per dwg D3724

4-Deburr

GA ml 08/04/16

✓ 08-04-22
✓ 08-04-22
✓ 08-04-22

W/O:		WORK ORDER CHANGES					
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Job Number: 38462

Part Number: D3724042

Job Number:



Seq. #: Machine Or Operation:

Description :

5-Apply magnabond as per dwg D3724
A/R Magnabond 6398 Batch: M106695

M 08-04-22/1

6-Rivet brackets in place on step as per dwg D3724

M 08-04-24/1

7-Weld both end cap as per Dwg D3724

M 08-04-24/1

8-Grind end cap welds flush

M 08-04-24/1

Inspect for foreign object per QSI 024

19.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S

08/04/24

(X)

20.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S

08/04/24

(X)

21.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.F.

08/04/24

1338462
D3724042

24/04/2008

22.0 POWDER COATING

POWDER COATING



M107550

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ff

08-04-24

S.114 13.58
#1 320.7 F
#2 ----- F
#3 320.115 F
#4 ----- F

23.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M.F.

08/04/24

24.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



M107385

Comment: Wing Walk as per Dwg D3043 and QSI 005 4.4

M.F.

08/04/24

25.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/24

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #: Machine Or Operation:

Description :

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 38442

LSD/28 (1)

27.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.04.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

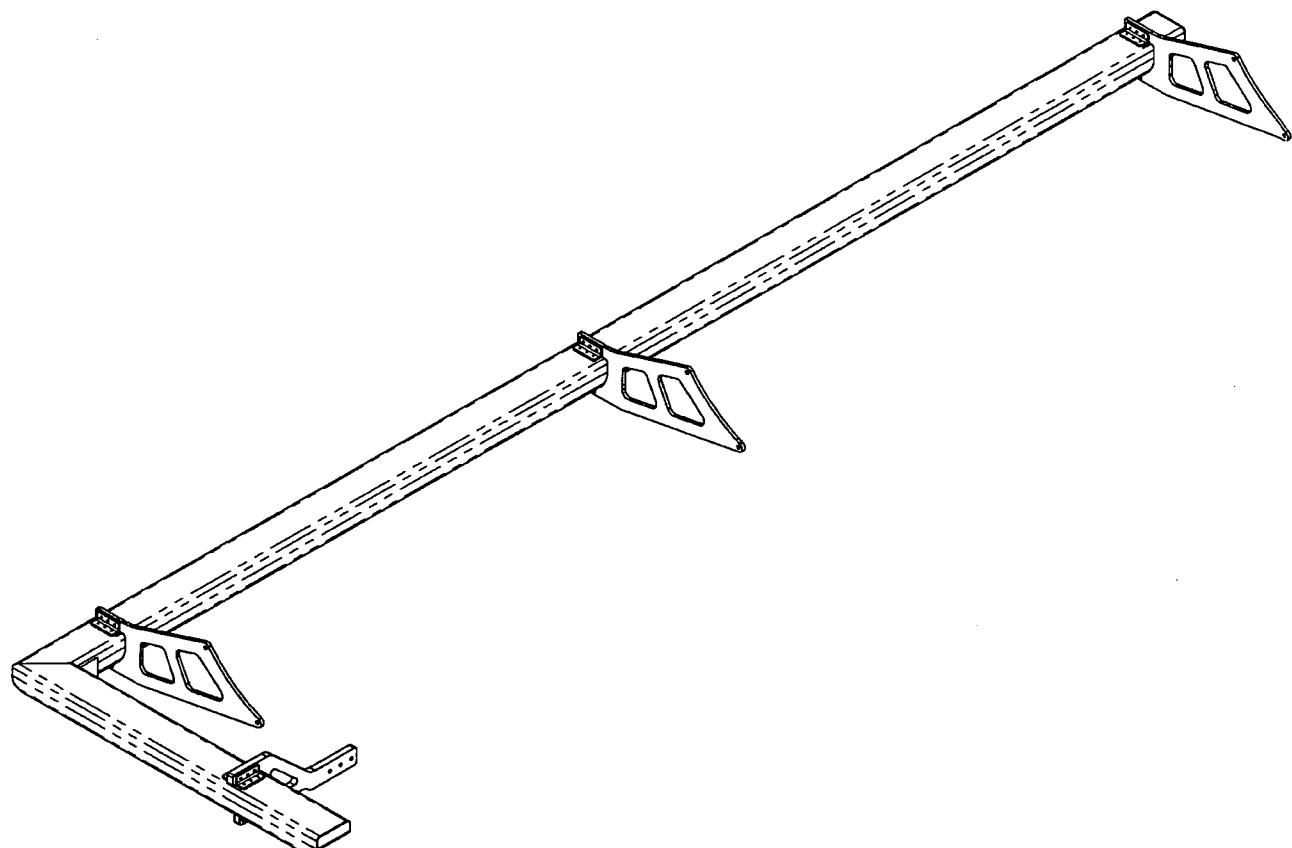
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3724-041	STEP ASSEMBLY
	X	D3724-042	STEP ASSEMBLY
2	2	D2734-1	END PLATE
8	8	D3730-1	ANGLE
1	1	D3733-1	GUSSET
1		D3737-1	STEP
	1	D3737-2	STEP
1		D3738-1	STEP
	1	D3738-2	STEP
1	1	D3747-1	DECAL
32	32	CR3216-5-4	RIVET
12	12	MS20470AD5-11	RIVET
4	4	MS20470AD5-16	RIVET
8	8	D3741-1	ANGLE
3	3	D3728-1	STEP BRACKET
1	1	D3729-1	STEP BRACKET



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WITHOUT NOTICE
WORK ORDER
NO. 38402

D3724-042 STEP ASSY (SHOWN)
D3724-041 STEP ASSY (OPPOSITE)

08-03-17
DRAFT

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: CHEMICAL CONVERSION COAT WELDMENT PER DART QSI 005 4.1 PRIOR TO ASSEMBLY
POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PER DART QSI 005 4.4 WHERE INDICATED
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 13.89 lbs
 - 8) WELDING: PER DART QSI 004
 - 9) APPLY MAGNOBOND 6398 BETWEEN MATING SURFACES WHERE INDICATED
 - 10) TOUCH UP CHEMICAL CONVERSION COAT ON ALL PARTS TRANSFER-DRILLED. (REF QSI 005 4.1)

B	ADD -041 ASSEMBLY. ADD D3747-1 DECAL TO P/L. SHEET 2 TRANSFER MARKING INSTRUCTIONS FOR INSTALLING D3730-1 & D3741-1 ON D3728-1 & D3729-1 DELETED. SHEET 2 DETAIL C, D & SECTION E-E Ø0.159 WAS Ø0.098. ZONE D4 53.16 DIM WAS 53.22, 2.60 DIM WAS 2.66. ADD SECTION G-G.	AJS	08.02.26
A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	IE	DRAWING NO.	REV. B
MFG. APPR.		D3724	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP ASSY	NTS
DATE	08.02.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

